

Date: Wednesday, 8/15/2007 7:56:14 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR AFT LH
Job Number : 33899	
Estimate Number : 11228	
P.O. Number : N/A	Part Number : D32813
This Issue : 8/15/2007 S.O. No. : N/A	Drawing Number : D3281 REV 0
Prsht Rev. : NC	Project Number : N/A C PRELIMINARY
First Issue : N/A	Drawing Revision : B
Previous Run : 30660	Material : N/A
Written By : <u>Jan/07-08-15</u>	Due Date : 8/22/2007
Checked & Approved By : _____	Qty: 10 Um: Each
Comment : Est Rev: A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL	

**ENGINEERING
APPROVAL**

Additional Product



Seq. #: Machine Or Operation: Description :

1.0 F6002 701 lexan black



POSITIVE
RECALL

Comment: Qty.: 4.3600 sf(s)/Unit Total : 43.6000 sf(s)
lexan black .125"

Material Batch # M103735 (x8)

M105952 (x10)

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



x8

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

3.0 THERMOFORMING THERMOFORMING MACHINE



x8

Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 009

Dwg. Rev. B

Folio Rev. B

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT LH

Job Number: 33899

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



PTD →

Comment: HAND FINISHING THERMOFORMING

DL 07/10/30 x10

1) Trim to Finished Dimensions

BB 07-10-05 (18)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

DL 07.10.05 (18)

2) Check dimensions to ensure conformity to drawing tolerances.

DL 07.10.30 x10

7.0

QC5

INSPECT WORK TO CURRENT STEP



POSITIVE
RECALL

Comment: INSPECT WORK TO CURRENT STEP

50710109

8.0

PACKAGING 1

PACKAGING RESOURCE #1



ENGINEERING
APPROVAL

07.11.06



Comment: PACKAGING RESOURCE #1

07/11/09 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
07/11/10

Job Completion



11.07.12

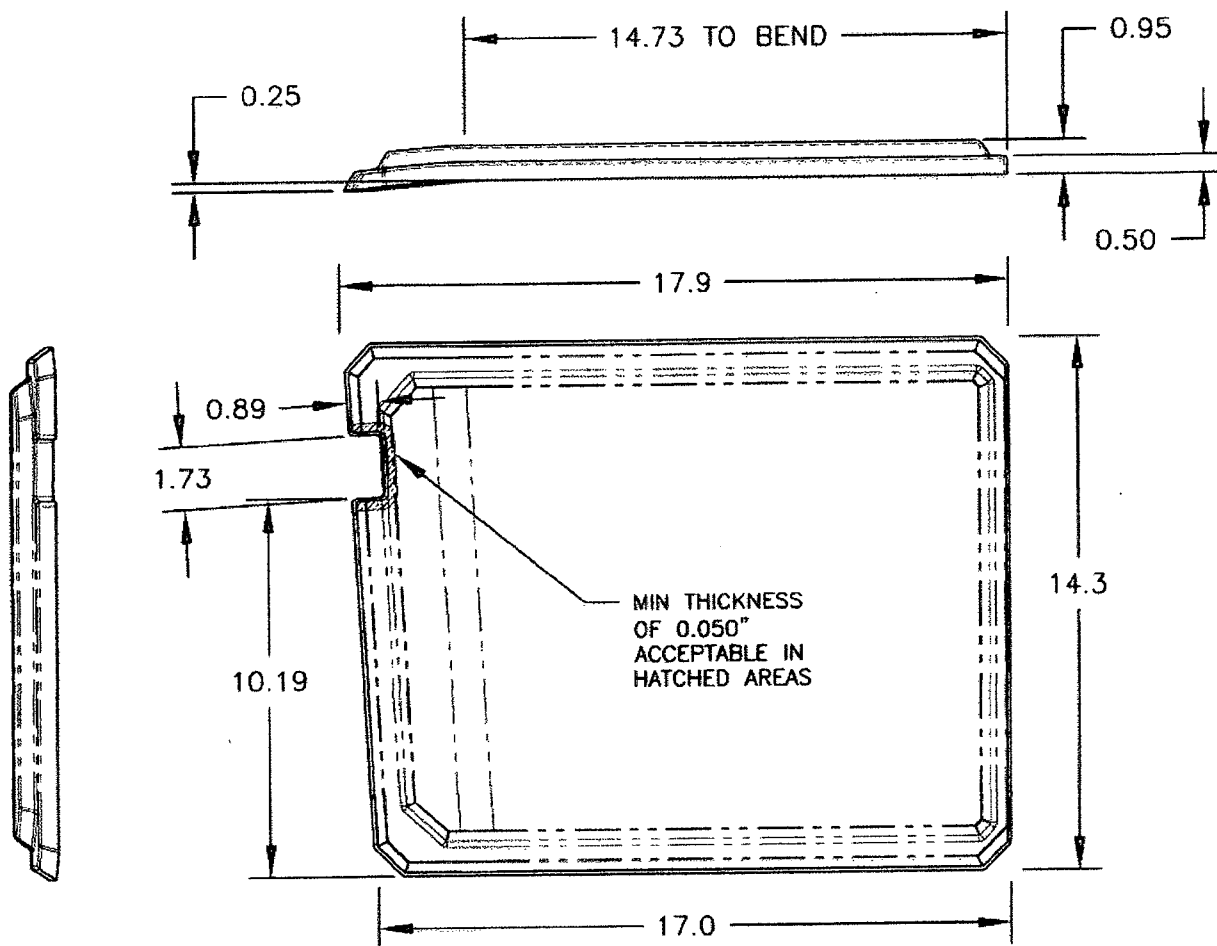
POSITIVE RECALL

EFFECTIVE 07.08.15 AUTH

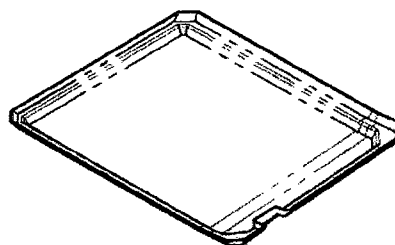
RELEASED 10 DATE 07.11.06



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ll</i>	APPROVED <i>ll</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



RELEASED
05.12.01



D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)

D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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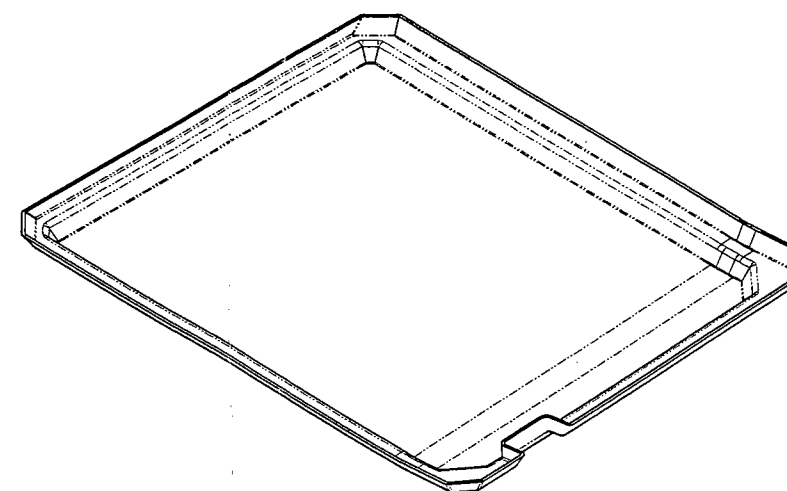
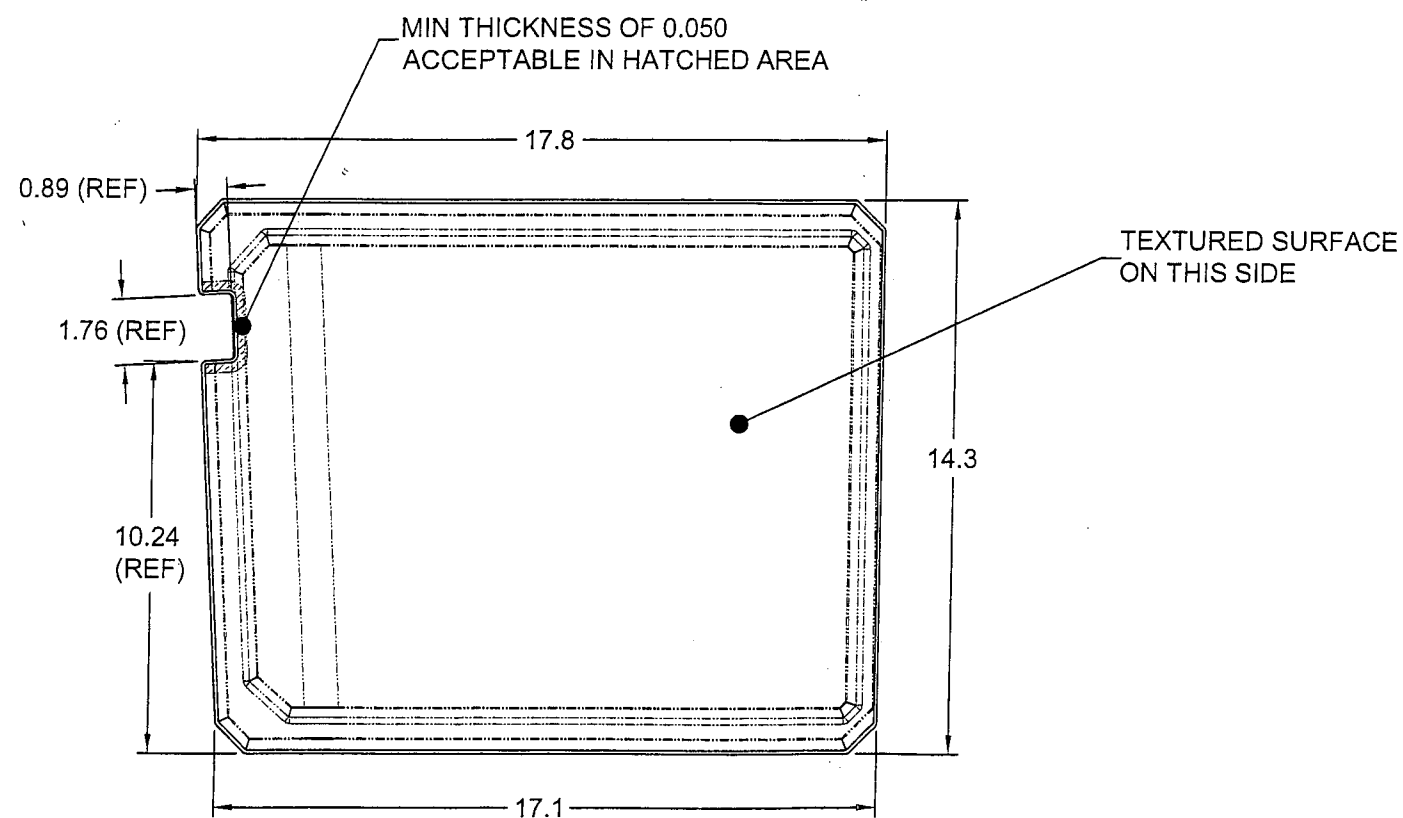
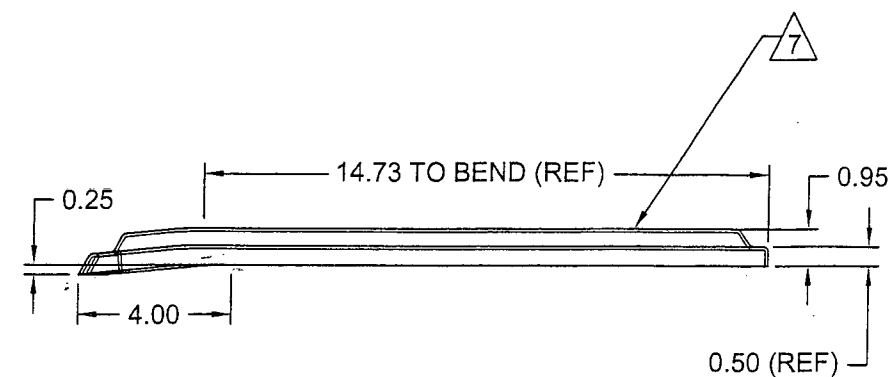
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.04	S.D	TRIMMED 0.25" EXTRA OFF TOP SURFACE ON OUTBOARD EDGE	<i>[Signature]</i> OT	ACCEPTABLE. ENSURE PARTS SHIPPED WITH W/O 33900.				

NOTE: Date & initial all entries



D3281-3 FLOOR PROTECTOR
(D3281-4 OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33899

PRELIMINARY ISSUE

LE 07.10.09

D3281-3/-4 NOTES:


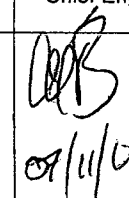
- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/-4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	HP	D3281	SHEET 3 OF 3
APPROVED	AMP	TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	07.10.09	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.25	6.	8 parts scrap not formed. material Batch. M103735	 07/11/05	Scrap & Replace.	07/10/25 Ph.	5 07/10/31	 07/11/05	5 07/11/31

NOTE: Date & initial all entries

DART AEROSPACE LTD	WORK ORDER:	33899
Description: R44 Floor Protector Rear LH	Part Number:	D3281-3
Inspection Dwg: D3281	Rev: B	Page 1 of 1

C Preliminary

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	W
Acceptable shape definition	PH
Acceptable texture retention	PH
Free of visual flaws (bumps, cracks, voids, etc.)	PH

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3281 Rev. ~~X~~ and record below

C Preliminary

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.1	.1	17.1	✓		TAPE	
17.8	.1	17.75	✓		TAPE	
14.3	.1	14.25	✓		TAPE	
10.24	.030	10.25	✓		TAPE	
.95	.030	.958	✓		TAPE	Acceptable
4.0	.030	3.125		✓	CAL	WRONG DIM ON DRAWING

UE
07.11.01

Measured by: <i>W</i>	Audited by: <i>S</i>	Prototype Approval: <i>UE</i>
Date: 07/10/31	Date: 12/10/31	Date: 07-11-01

Rev	Date	Change	Revised by	Approved
		New Issue		